

Work Order ID 68146

Thursday, April 07, 2011 8:17:46 AM

Page 1

Item ID: D4324-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Armrest Assembly

Start Date: 4/7/2011 Start Qty: 2.00

Required Date: 4/8/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *11-04-08* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4324

A

100

Weld per dwg A/R S.S. rod Batch: *M114509* 0.00

Large Fab

Memo

0.00

Large Fab

EL 11-48 (2)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

CP 11-04-08

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

*Subtotal**(2)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 51

0.00



Packaging

Memo

0.00

Packaging

MF 11-04/08

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/8 JF

MF
11-0408

W/O:		WORK ORDER CHANGES						
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Picklist Print

Thursday, April 07, 2011 8:17:38 AM

Page 1

Work Order ID: 68146

Parent Item: D4324-041

Parent Item Name: Armrest Assembly







Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-1  Base Plate		Manufactured	No			100	Each	0.0000	1	2			
					B68148 X 2						EL	11-4-8	
D4324-5  Tube		Manufactured	No			100	Each	0.0000	1	2			
					B68150 X 2						EL	11-4-8	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

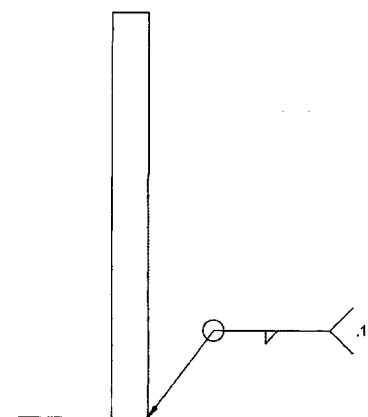
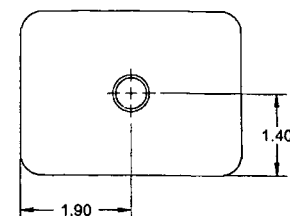
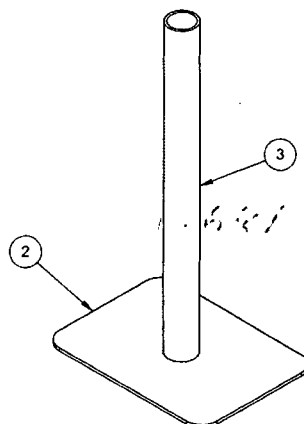
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4324-041	ARM REST ASSEMBLY
2	1	D4324-1	BASE PLATE
3	1	D4324-5	TUBE



D4324-041 ARM REST ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.36 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE	RF	11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.01.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4324** REV. A
SHEET 1 OF 5

TITLE **VRD PARTS** SCALE NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

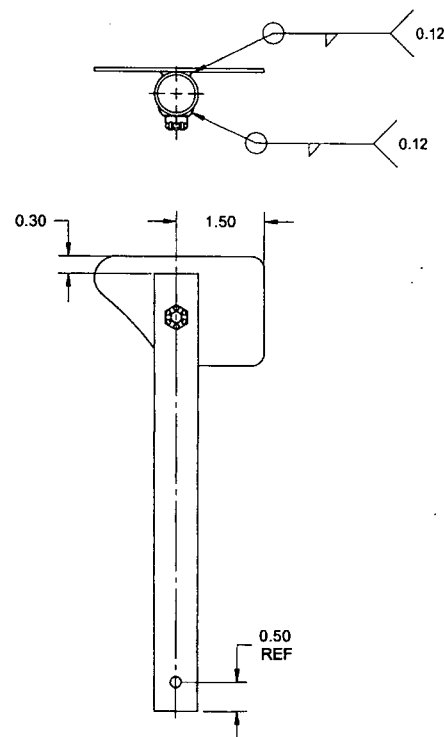
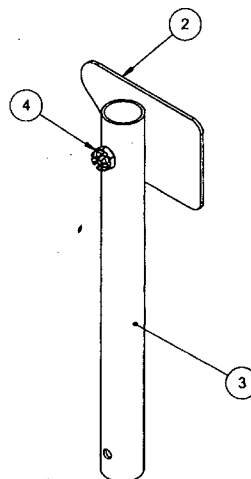
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4324-043	ARM SUPPORT ASSEMBLY
2	1	D4324-3	SUPPORT PLATE
3	1	D4324-7	TUBE
4	1	AN310C3	NUT, CASTELLATED



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

#68144

RELEASED
2011-04-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

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MFG. APPR.	<i>[Signature]</i>	D4324	SHEET 2 OF 5
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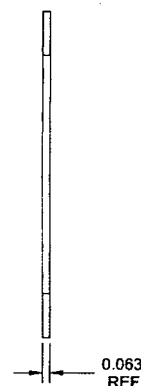
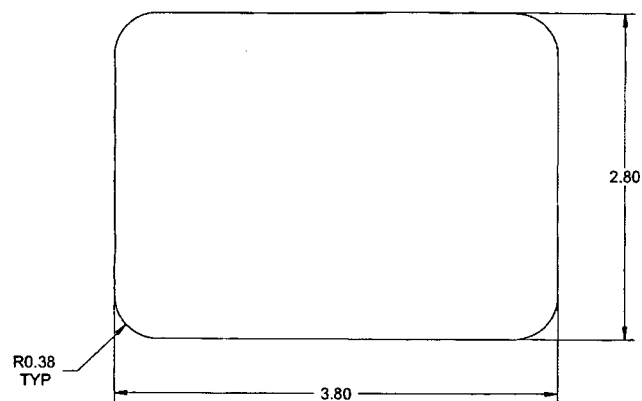
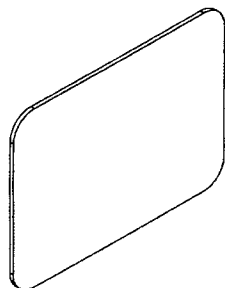
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#68146

D4324-1 BASE PLATE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

RELEASED
2011-04-06

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

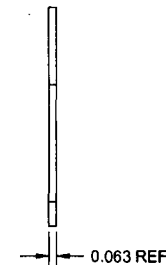
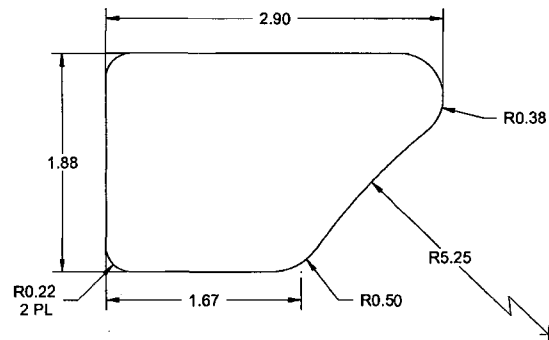
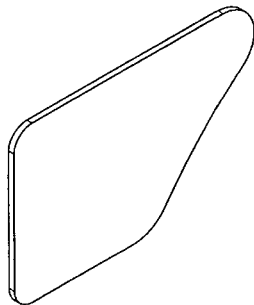
C

B

B

A

A



#68146

D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED
2011-04-06
JWB

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D4324	REV. A
MFG. APPR.	RF	SHEET 4 OF 5	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

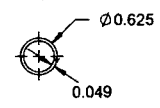
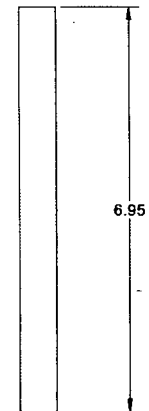
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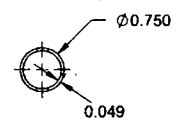
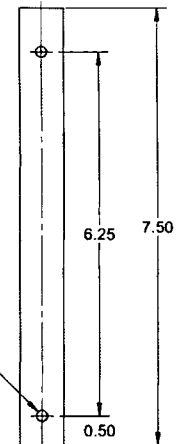
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4324-5 TUBE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)



D4324-7 TUBE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

#68146

RELEASED
2011-04-06

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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8 7 6 5 4 3 2 1

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